

Date: Friday, 17/08/2007 11:21:00 AM
 User: Linda Lacelle

Process Sheet

pld
 27/10/03

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 34080 - 2
 Estimate Number : 12304
 P.O. Number : N/A
 This Issue : 17/08/2007 S.O. No. : N/A
 Prsht Rev. : NC
 First Issue : N/A Type : SMALL /MED FAB
 Previous Run : 32039
 Written By : 18/07/08 20
 Checked & Approved By : 18/07/08 20
 Comment : Est Rev: A New Issue 06-04-24 EC
 Est Rev: B As per Rev B 06-05-24 JLM

Drawing Name : AFT PLATE ASSEMBLY
 Part Number : D3467045
 Drawing Number : D3467 REV B
 Project Number : N/A
 Drawing Revision : B
 Material : N/A
 Due Date : 11/09/2007

Qty: 4 Um: E

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D3467049

BAFFLE & DEFLECTOR ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3467-49	Baffle ass'y	B34092 x 3 mx, B34490 x 1 mx

mf

2.0

D34673

TUBE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3467-3	Tube	B34099 x 8mx, B34490 x 1mx

mf

3.0

D34675

AFT PLATE



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3467-5	aft plate	B34100

mf

4.0

D346711

BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3467-11	Bracket	B26781 x 2mx, B34094 x 6mx

mf

07-10-

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07/10/23	10	split into	JB	07/10/23	1		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

CU-DAR001 Dart Helicopters Services

Drawing Name: AFT PLATE ASSEMBLY

Number: 34080

Part Number: D3467045

ber:



Seq. #:

Machine Or Operation:

Description:

5.0

D346717

TOP COVER



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3467-17	Shourd Plate

Batch

B 34095 x 4mx

mf

6.0

D346719

DOUBLER



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3467-19	Doubler

Batch

B 34096 x 4mx

B 34097 x 4mx

mf

7.0

D346720

doubler RH



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)

Pick:

Qty	Part Number	Description
1	D3467-20	Doubler

Batch

B 34098 x 4mx

B 32048 x 1mx

mf

8.0

NAS1031C3W

Nutplate



Comment: Qty.: 4.0000 Each(s)/Unit Total: 16.0000 Each(s)

Nutplate

m105728

mf

07-10-15

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3467

2-Spot Weld as per Dwg D3467 and Dart QSI 004

3-Identify as D3467-045

mf 07-10-15

Process Sheet

CU-DAR001 Dart Helicopters Services

Drawing Name: AFT PLATE ASSEMBLY

Number: 34080

Part Number: D3467045

ber:



Seq. #:

Machine Or Operation:

Description :

10.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07/10/23

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/10/23

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

mf 07-10-23

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D. 07/10/23

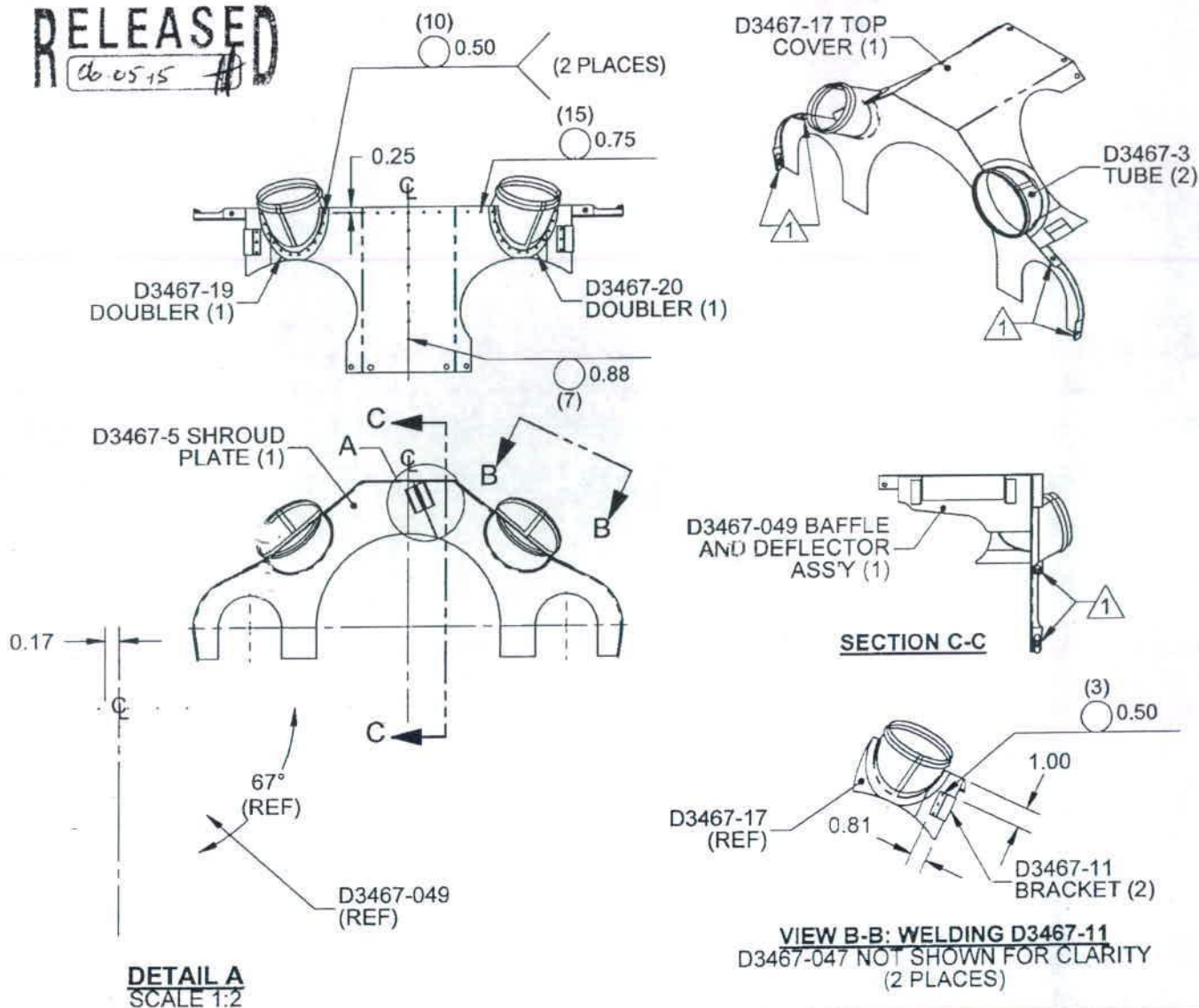
Job Completion



u 07.10.23 ①

DART

DESIGN <i>B</i>	DRAWN BY <i>B</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. D3467	REV. B SHEET 3 OF 15
DATE 06.05.15	TITLE SHROUD ASSEMBLY		SCALE 1:8

RELEASED
06.05.15**D3467-045 AFT PLATE ASSEMBLY****NOTES:**

- 1) LOCATE AND SPOT WELD NAS1031C3W NUTPLATE (4) TO D3467-5 PRIOR WELDING OTHER PARTS TO D3467-5
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -045	P/N	DESCRIPTION
X	D3467-045	AFT PLATE ASSEMBLY
1	D3467-049	BAFFLE AND DEFLECTOR ASSEMBLY
2	D3467-3	TUBE
1	D3467-5	SHROUD PLATE
2	D3467-11	BRACKET
1	D3467-17	TOP COVER
1	D3467-19	DOUBLER
1	D3467-20	DOUBLER
4	NAS1031C3W	NUT PLATE

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SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 25

EMPLOYEE: Melanie Fauter

PART NUMBER: D3467-015

JOB NUMBER: B34080

MATERIAL TYPE: 304L

MATERIAL THICKNESS: .018

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium, SS

TEST RESULTS

	PASS	FAIL
VISUAL:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PENETRATION:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]
PULL STRENGTH:	[<input checked="" type="checkbox"/>]	[<input type="checkbox"/>]

PSI Reading: _____

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/01/17

QUALIFIER: SB

